

shp 15/04 if possible

Dart Aerospace Ltd.

Date: Tuesday, 14/04/2009 8:48:20 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CABIN FLOOR PROTECTOR
Job Number :	47130		
Estimate Number :	12970		
P.O. Number :		Part Number :	D35746
This Issue :	14/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3574 REV.A
First Issue :	/ /	Project Number :	N/A
Previous Run :	45191	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/04/2009
Written By :		Qty:	4
Checked & Approved By :		Um:	Each
Comment :	Est Rev :A New Issue 07.07.23 EC verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s)
lexan sheet
Batch: 109455 B9-4-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3574
Dwg Rev: A
Prog Rev: A

B9-4-15

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B9-4-15

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/04/15 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 09-04-16 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/04/2009 8:48:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 47130

Part Number: D35746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/04/16 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: PIP 47128

809/04/16 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

809/04/16 (4)
mf 09-04-16

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	4730
Description: Cabin Floor Protector		Part Number:	D3574-6
Inspection Dwg: D3574 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.001	*			
7.38	+/-0.030	7.38	*			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
25.87	+/-0.030	25.87	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			
58.38	+/-0.030	58.38	*			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	✓			
10.25	+/-0.030	10.25	*			
11.87	+/-0.030	11.87	*			
14.75	+/-0.030	14.75	*			
26.00	+/-0.030	26.00	*			
40.87	+/-0.030	40.87	*			
45.00	+/-0.030	45.00	*			
48.00	+/-0.030	48.00	*			
55.13	+/-0.030	55.13	*			
61.25	+/-0.030	61.25	*			
61.88	+/-0.030	61.88	*			
64.63	+/-0.030	64.63	*			
1.13	+/-0.030	1.13	*			
7.63	+/-0.030	7.63	*			
11.00	+/-0.030	11.00	*			
22.10	+/-0.030	22.10	*			
22.50	+/-0.030	22.50	*			
24.50	+/-0.030	24.50	*			
35.13	+/-0.030	35.13	*			

DART AEROSPACE LTD		Work Order: 47136
Description: Cabin Floor Protector		Part Number: D3574-6
Inspection Dwg: D3574 Rev: A		Page 2 of 2

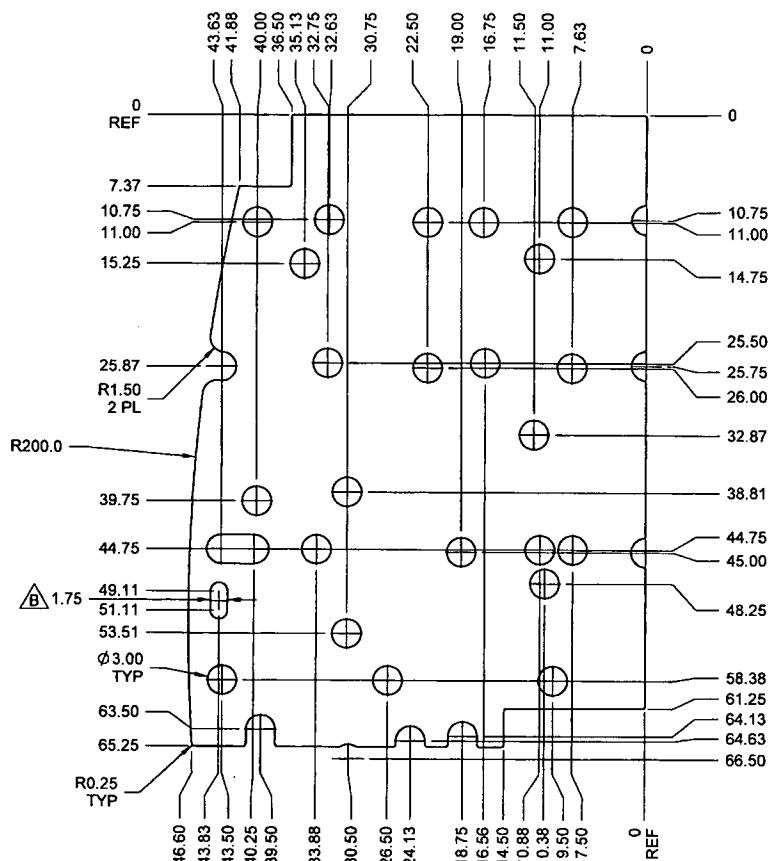
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.50	+/-0.030	36.50	*			
40.00	+/-0.030	40.00	*			
41.88	+/-0.030	41.88	*			
43.63	+/-0.030	43.63	*			
6.75	+/-0.030	6.75	*			
9.50	+/-0.030	9.50	*			
10.38	+/-0.030	10.38	*			
14.50	+/-0.030	14.50	*			
16.75	+/-0.030	16.75	*			
18.94	+/-0.030	18.94	*			
19.00	+/-0.030	19.00	*			
24.13	+/-0.030	24.13	*			
33.88	+/-0.030	33.88	*			
39.50	+/-0.030	39.50	*			
40.25	+/-0.030	40.25	*			
43.50	+/-0.030	43.50	*			
46.60	+/-0.030	46.60	*			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-4-15	Date: 09/04/15	Date:	N/A

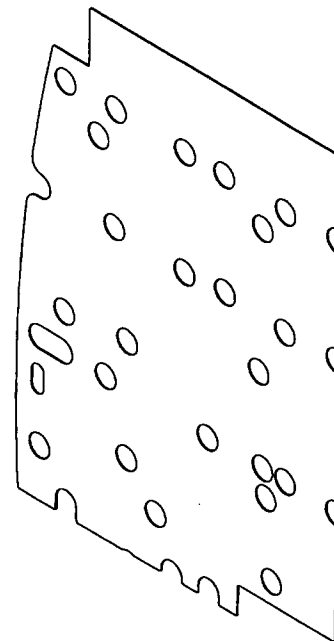
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961



RELEASED
01/24/07

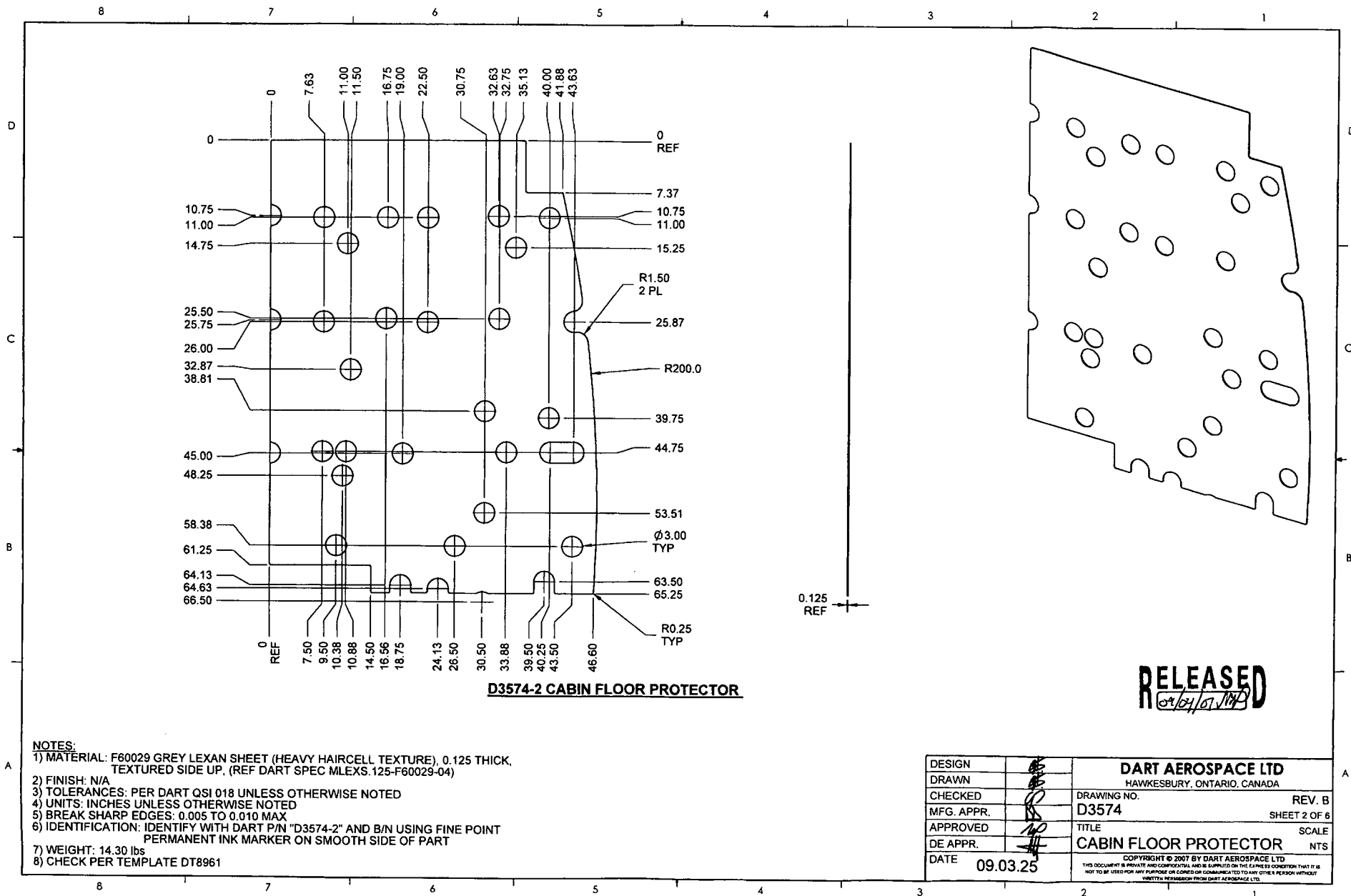
B	ADD CUT-OUT TO -1/5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

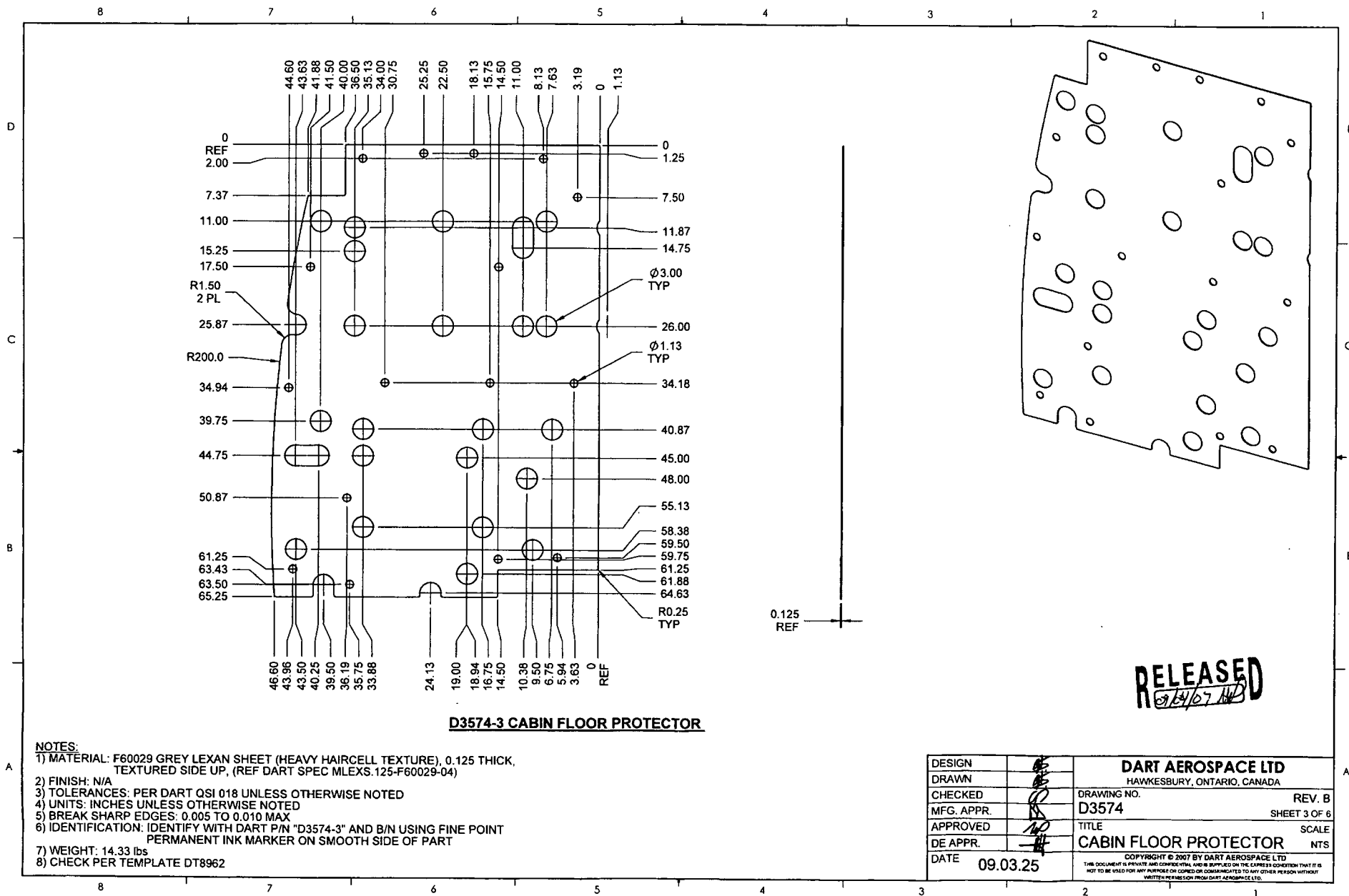
DRAWING NO. **D3574** REV. B
SHEET 1 OF 6

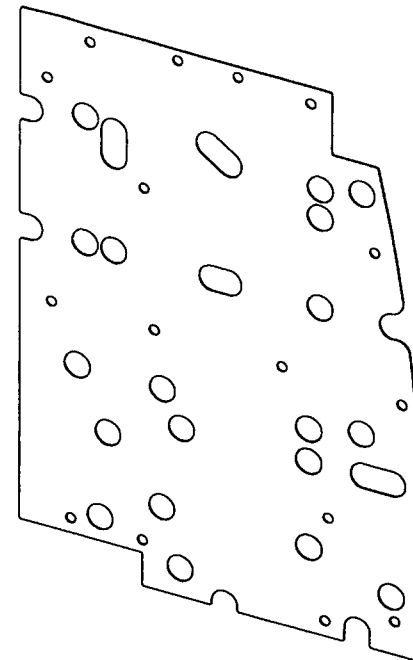
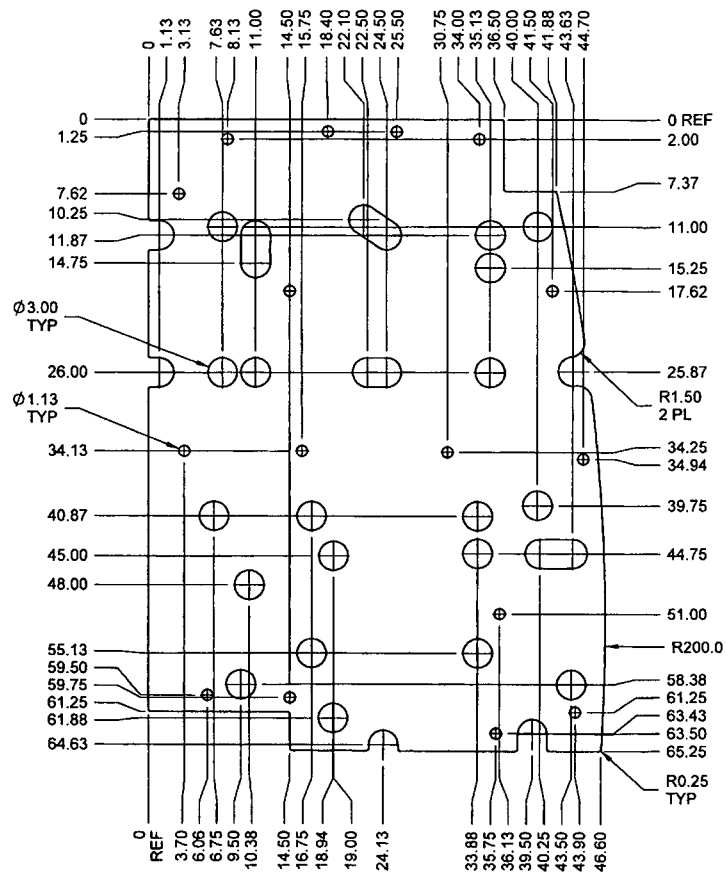
TITLE **CABIN FLOOR PROTECTOR** SCALE NTS

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RELEASED
09/04/07 JH





D3574-4 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963

RELEASED
9/15/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3574	REV. B
MFG. APPR.		SHEET 4 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
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